

Work Order ID 83165

April-13-12 10:38:03 AM

83165

Page 1

Item ID: D4012-1

Accept

N900040100Setup Start ***NS1***

Revision ID:

Item Name: Cushion

Stop ***NS2***

Start Date: 13/04/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 27/04/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals:

Process Plan: MLJDate: 12/04/13 Tooling:

Date:

Run Start ***NR1***

QC:

Date: _____ SPC (Y/N): _____

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D4012

B

100

0.00

100

Mill Conv

Memo

0.00

12-4-1842

Conventional Milling Machine

110

QC2- Inspect parts off machine FAI/FAIB

0.00

110

QC

Memo

0.00

12-4-1842

Quality Control

120

QC8- Inspect parts - second check

0.00

120

QC

Memo

0.00

12/04/1442

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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N900040100

Setup Start *NS1*

Stop ***NS2***

Start Date: 13/04/2012 **Start Qty:** 40.00 ***40***

Required Date: 27/04/2012 **Req'd Qty:** 40.00 ***40***

Reference:

Approvals: **Process Plan:** _____ **Date:** _____ **Tooling:** _____ **Date:** _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

0.00

123

Memo

0.00

CLAMP AND FORM CUSHION AS PER DWG BY SLIGHTLY HEATING IT WITH HEAT GUN, LET IT COOL DOWN BEFORE REMOVING CLAMP.

QC5- Inspect part completeness to step on W/O

0.00

126

Memo

0.00

Quality Control

Identify as per dwg & Stock Location. S-2459 0.00

130

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

140

QC21- Final Inspection - Work Order Release

0.00

140

QC

Memo

0.00

Quality Control

12/6/12
ME
12-06-05

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

April-13-12 10:38:07 AM

Page 1

Work Order ID: 83165

83165

Parent Item: D4012-1

D4012-1

Parent Item Name: Cushion

Start Date: 13/04/2012

Required Date: 27/04/2012

Start Qty: 40.00

Required Qty: 40.00

Comments:

IPP RevA: New issue 09.10.28 DD verified by:JLM

IPP RevB:

revA as per dwg 09.11.18 DD verified by:JLM

IPP Rev:C 11.01.10

as per dwg Rev.B DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4287-3		Manufactured	No			100	f	20.0000	0.37	15.57895			

D4287-3

UHMW U-Channel

**

Location

Loc Qty

Loc Code

MAT055

20

70348

20

16.8 90 12-4-18

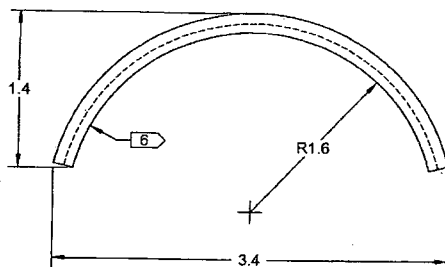
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

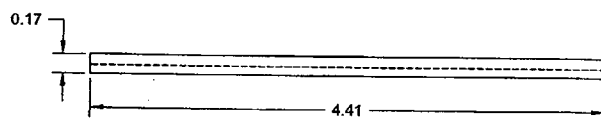
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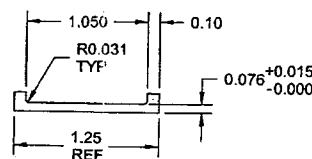
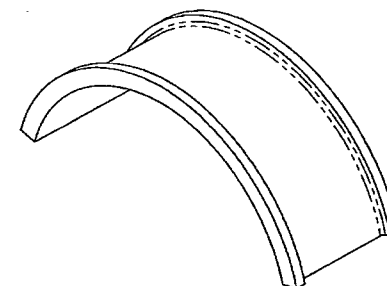
D4012-1 CUSHION
(MAKE FROM D4012-1F)



D4012-1F FLAT MACHINED STATE

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83165 MLJ

12/04/13



RELEASED
2010-12-23
JMB

- NOTES:
- 1) MATERIAL: MAKE FROM D4287-3
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4012-1" AND B/N "BXXXXX" PER QSI 044 6.1
 - 7) WEIGHT: 0.02 lbs

B		CHANGED RAW MATERIAL TO REDUCE MANUFACTURING COSTS; PART NOW MACHINED FLAT AND SHAPED WITH RADIUS. REF: PAR10-29	MB	10.12.07
A		NEW ISSUE	MB	09.10.19
REV.	DESCRIPTION		BY	DATE
DESIGN	 DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. B	
DRAWN			DRAWING NO. D4012	
CHECKED			SHEET 1 OF 1	
MFG. APPR.			TITLE CUSHION	
APPROVED			SCALE NTS	
DE APPR.	 10.12.07		COPYRIGHT © 2009 BY DART AEROSPACE LTD	
DATE			THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE, OR COPIED OR REPRODUCED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	